












Wednesday, 3/8/2006 10:37:51 AM

User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHROUD ASSEMBLY
Job Number	: 26108 -1	Part Number	: D34675
Estimate Number	: 12219	Drawing Number	: D3467 REV.A
P.O. Number	: NIA	Project Number	: N/A
This Issue	: 3/8/2006 S.O. No. : NIA	Drawing Revision	: A
Prsht Rev.	: NC	Material	: NIA
First Issue	: NIA Type : PURCHASED PARTS	Due Date	: 3/31/2006
Previous Run	: NIA	Qty:	10 Um: Each
Written By	: <u>SAC COMMENT Below</u>		
Checked & Approved By	: <u>06.03.08</u>		
Comment	: est rev. A 06.02.06 new issue EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	OUTSIDE SERVICE	OUTSIDE SERVICES	
			
Comment: Sub-Contracting Issue P/O: <u>00000768</u> <u>06/03/09</u> Email or Ship DXF file to vendor Laser Cut per Dwg D3467 flat pattern D3467-5F Material release note required			
2.0	D34675F	AFT PLATE FLAT PATTERN	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) DOUBLER FLAT PATTERN			
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached			
4.0	QC6	DIMENSIONAL CHECK	
			
Comment: DIMENSIONAL CHECK			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Debur SAP 06.03.22 (10) 2-Form as per dwg D3467 using DT8855			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/03/31
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD ASSEMBLY

Job Number: 26108

Part Number: D34675

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



26.03.30 (4)



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

26.03.30 (4)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

26.03.30 (4)

Job Completion



26.03.30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:37:51 AM
 User: Kim Johnston

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SHROUD ASSEMBLY
 Job Number : 26108 -2
 Estimate Number : 12219
 P.O. Number : N/A Part Number : D34675
 This Issue : 3/8/2006 S.O. No. : N/A Drawing Number : D3467 REV.A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : A
 Previous Run : N/A Material : N/A
 Written By : SAL COMMENT BELOW Due Date : 3/31/2006 Qty: 10 Um: Each
 Checked & Approved By : 06.03.08
 Comment : est rev. A 06.02.06 new issue EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 OUTSIDE SERVICE OUTSIDE SERVICES



Comment: Sub-Contracting Issue P/O: 00000768 06/03/09
 Email or Ship DXF file to vendor
 Laser Cut per Dwg D3467 flat pattern D3467-5F
 Material release note required

2.0 D34675F AFT PLATE FLAT PATTERN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10000 Each(s)
 DOUBLER FLAT PATTERN

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

06.03.22 (10)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06.03.22 (10)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Deburr SAP 06.03.22 (10)
 2-Form as per dwg D3467 using DT8855

06.03.23 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	5	One Label Ser Template	B	060323		B 04/04	B 060323

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes NO DQA: B Date: 06/04/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:37:51 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD ASSEMBLY

Job Number: 26108

Part Number: D34675

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB

06/04/25

⑤

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

120604-25

⑤

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/26

⑤

Job Completion



06/04/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

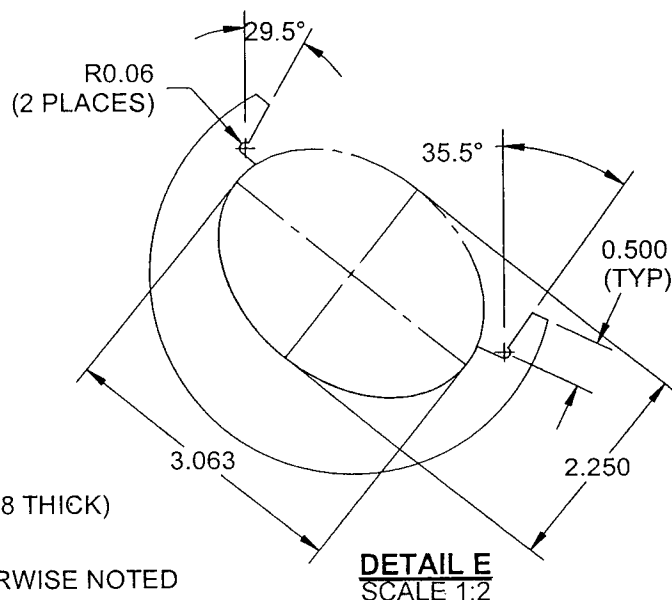
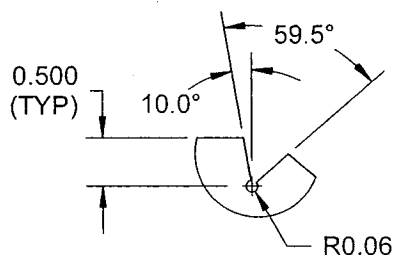
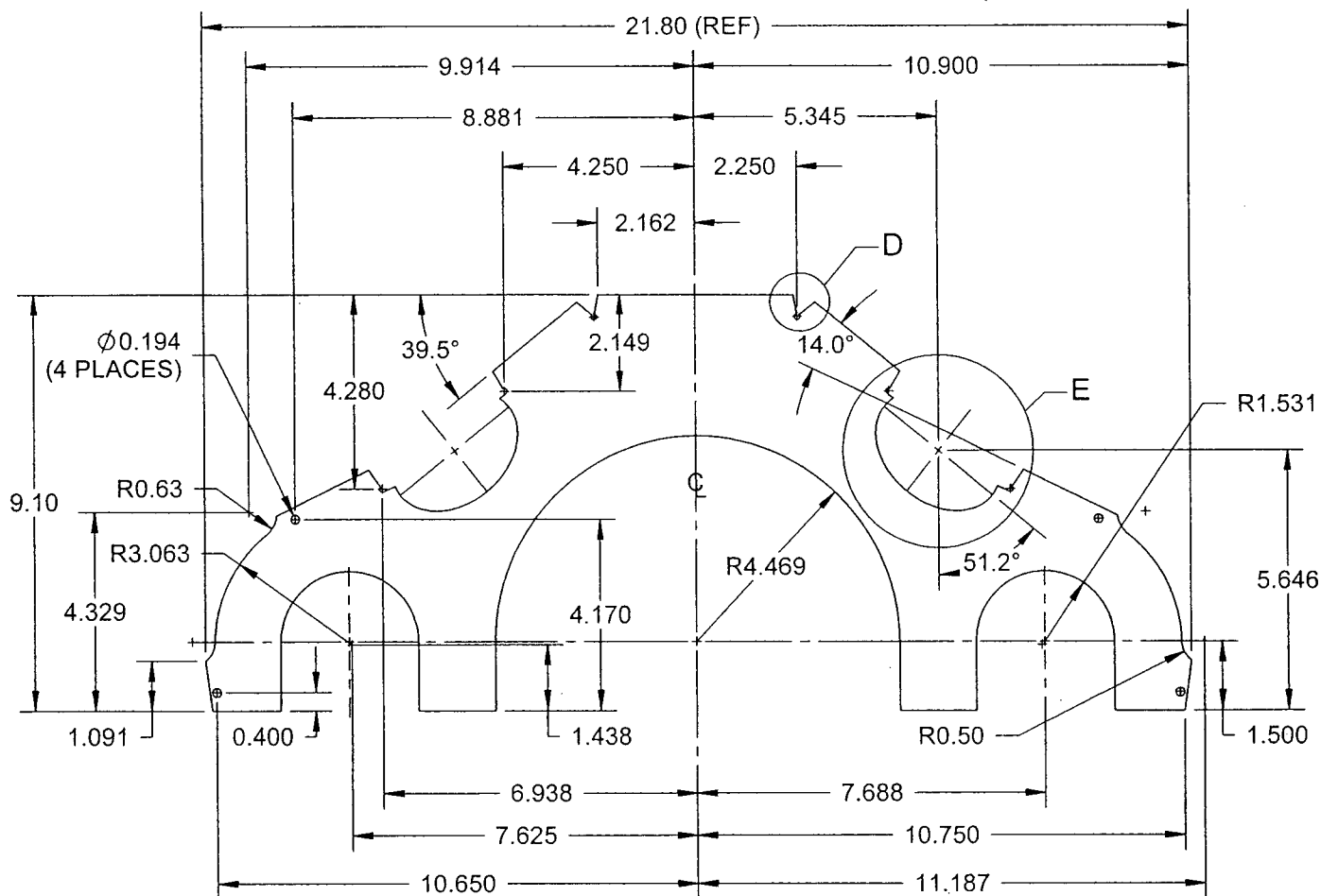
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3467	REV. A SHEET 8 OF 15
DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:8



D3467-5F AFT PLATE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019
(ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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4. 465
4. 469

8. 930

Ryerson 3/17/2006 1:57 PAGE 001/002 FAX SERVER

3/17/2006 1:57

PAGE 001/002

EX-105

MAY-17-2005 10:05

FIELD-INTERVIEW

253-288-3638

F-126 P-007/016 F-687

AK Steel		AK Steel Corporation Metallurgical Test Report Cleveland Works Cleveland, OH 44112		Pgs: 1								
INTEGRIS METALS PO BOX 340 MINNEAPOLIS, MN 55440		S INTEGRIS METALS 306 1 ST STREET AUBURN, WA 98001										
CUSTOMER	ORDER NO.	MILL ORDER NO.		BUYER'S ORDER NO.								
UNITED STATES STEEL CORP.	720013140	72001-0191		427135-01								
		PAINT NO. 74351497										
		<input checked="" type="checkbox"/> EXHAUSTION UNIT --PRODUCT-- NITRIC UNITS DIMENSION 48.000 X COIL										
SKID ID	PCEB	HEAT	PARENT COIL ID	NET WEIGHT								
SKD72013140	1	7200131	0659919-02	3,456 LBS. 4012 KG.								
SKD72013144	1	7200131	0659919-01	3,470 LBS. 4023 KG.								
SKD72013145	1	7200131	0659919-01	3,453 LBS. 4003 KG.								
SKD72013149	1	7200131	0659919-02	3,444 LBS. 3992 KG.								
TOTAL SKIDS	4			TOTAL NET WEIGHT 13,744 LBS. 15,020 KG.								
Lab Analysis of Heat P-Product Analytical Patent Conf												
ID	C	MN	P	S	SI	CR	NI	MO	N	CU	CO	
L 7200131	.049	1.39	.027	.001	.35	18.18	8.05	.35	.04	.30	.12	
SHIPPING DATE: 09/14/2005		REMARKS		NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS, RADIUM, ALPHA SOURCE, AND LOW MELTING ALLOYS ON ELEMENTS CAPABLE OF FORMING LOW MELTING ALLOYS WERE MADE THROUGHOUT THE PROCESSING OF THIS MATERIAL.								
PRODUCT DESCRIPTION												
CR SET TYPE 304 STAINLESS #28 FINISH SLIT EDGE 1 ARE 361.2 E ALL TUBE REELS HAVE 28H RTT UNLESS NOTED TO OR NOTED OTHERWISE * A SIZE N 240 -04 EX PARA 3.1.3 B LONG WILL BE DETERMINED BY ASTM E 9 * ASKS A 490 -01 EX PARA 1.9.1.1 B LONG WILL BE DETERMINED BY ASTM H E S EX PARA 26.1.1.3 COIL WILL BE TAGGED ON OUTSIDE ONLY * ASTM E 866 -03 * IN-011 Rev 0, * TR-011 O * BUYER PART# 78251497 * ASME SB-240 SECTION II PART B (2001 ED, 2002 AMEND) EX PARA 3.1.3 B LONG WILL BE DETERMINED BY ASTM E 9 * EX-10204 3.1.3												
PARENT COIL	FOR	DIR	COND	% ELONG	TENSILE	Y.S.	ROCKWELL	ROCKWELL				
ID	(PTG)	(L, T, D)	Z INCH	MEASURED	STRENGTH	% OFFSET	HARDNESS	HARDNESS				
720013140					(KSI)	(RHS)	F	F				
720013140					37.1	37.1	72	74				

*** CONTINUED ON NEXT PAGE ***

Fax Server

T-726 P.008/015 F-527

<h1 style="margin: 0;">AK Steel</h1>										AK Steel Corporation Metallurgical Test Report Coshocton Works Coshocton, OH 43812										Page 2	
INTERIOR METALS PO BOX 300 MINNEAPOLIS, MN 55400										INTERIOR METALS 308 "B" STREET AUBURN, WA 98001										Lot No 7410672 BRN No 7410672	
CDSTOHEE										MILL ORDER NO. 27734-091 PROCESSOR ORDER NO. 427136-01 BUYERS ORDER NO. 427136-01										Part No 7421407	
ENGLISH UNITS - PRODUCT - METRIC UNITS 5713 NOM 48000 X COIL																					

PARENT COIL	POS	DIR	COND	ASTM	BEND															
ID	(W/T)	(L, T, D)		ASTM	180															
	T			PRACTICE	17															
056919-02				ASTM	PASS															
PARENT COIL	POS	DIR	COND	BELONG	STRENGTH	T.R.														
ID	(W/T)	(L, T, D)		MEASURED	(KSI)	26 OFFSET														
056919-02	F	T	A.S.T.M	71.0	92.8	33.1														
PARENT COIL	POS	DIR	COND	BEND																
ID	(W/T)	(L, T, D)		180																
056919-02	F	T	A.S.T.M	PASS																

THE COSHOCTON METALLURGICAL TEST REPORT IS NOT GUARANTEED TO A CUSTOMER'S PROPERTY, PURCHASED FROM AK STEEL CORPORATION. NO AVOID THE LIABILITY OF THIS REPORT ON BEHALF OF THE REPORT TO A REPORTER'S PROPERTY. MUST BE MAINTAINED BY AND UNDER THE NAME OF BUYER'S COMPANY.		SIGNED <i>Steve Kagan</i> DATE 05/12/2009 TIME 10:45 AM AUTHORIZATION NUMBER	
-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	--	---------------------------------------------------------------------------------	--

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 1
Heat/Lot : 86K8
TIN : B42748

Sold To: INTEGRIS METALS, LTD.
7910 40TH STREET SE
CALGARY, AB T2C2Y3

Ship To: ***CUSTOMER PICKUP***
4375 14TH STREET NORTHEAST
CALGARY
ABT3E7A9

Vendor Information

Cust PO #: 406824

Cust PO DT: 11/03/05

Specifications

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/04a 480/04a, 666/03, ASMESA240/04-A05, 480/04-A05, SA666/04
Q08766D-A X 1/8 FRM, AMS5513H X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS
CORROSION: ASTM A262/02aB; 180Bend-OK

Buyer Part: 4288441

304 2B .1305 IN 48 IN 96 IN

Country of Origin: UNITED STATES

Mechanical Tests

		UOM	L	O		UOM	L	O
Yield Strength - 0.2% Offset	40	KSI	F	TRANSV				
Tensile Strength (UTS)	93.3	KSI	F	TRANSV				
Rockwell B	85		F	TRANSV				
Pct Uniform Elong 2 In/50mm	57.01	PCT	F	TRANSV				
Rockwell A	85		T	TRANSV				

Chemical Composition

C Carbon-Pct	.059	CR Chromium-Pct	18.360
CU Copper-Pct	.342	MN Manganese-Pct	1.643
MO Molybdenum-Pct	.285	N Nitrogen-Pct	.037
NI Nickel-Pct	8.150	P Phosphorus-Pct	.029
SI Silicon-Pct	.289		

Comments

1001
003/004
004

INDUSTRIAL LASER CUTTING
INTEGRIS METALS

03/17/2008 14:37 FAX 604 946 4153
04/20/2015 08:27 FAX

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 INDUSTRIAL ROAD NORTH

Page : 2
Heat/Lot : 86K8
TIN : B42748

Material free from mercury contamination. No weld repairs.
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 Q08763F Cond A
This document certifies the material has been tested in
accordance with applicable specifications described herein
and has met those requirements.

QA by ERIC HESS 02/01/2006

Miscellaneous Data

GUKLPH, ONN K123
Control #: 90C60214
Part #: 74270441
.135 X 48 X 96

Date: 03/17/06

SOLD TO: INDA LASH

TO 110880

S/O 90-374786 - 02

[Signature] 3/17/06

The Chemical Analysis and Mechanical Test
data was received via EDI from the above
mentioned vendor.

INTEGRIS METALS, LTD.

Date: Friday, 6/2/2006 11:44:18 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D3467-1/-2/-5/-9/-15/-17
Job Number : 27328	
Estimate Number : 10804	
P.O. Number : NIA	Part Number : Z_CUSTOM
This Issue : 6/2/2006 S.O. No. : NIA	Drawing Number : REWORK
Prsht Rev. : NC	Project Number : NIA
First Issue : NIA Type : NIA	Drawing Revision : NIA
Previous Run : 00015	Material : NIA
Written By : SEE COMMENT BELOW	Due Date : 6/9/2006
Checked & Approved By : SEE ABOVE USER & DATE	Qty: 1 Um: Each
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

REMOVE THE FOLLOWING PARTS FROM STOCK AND REWORK
 PER DRWG D3467 REV.B

D3467-1/-2 B OPEN HOLES AT .250 ✓

D3467-5/B OPEN HOLES AT .203

D3467-8 B OPEN HOLES AT .250

D3467-15 B OPEN HOLES AT .250

D3467-17 B OPEN HOLES AT .250 ✓

-1 B 26629 -2 B 26980

B 26108-2

no hole dimension change

B 2614

SB 06/06/03

2.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

J 06-06-06

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

RESTOCK PARTS USING ORIGINAL B/N

57446

2 6/6/0

4.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL
 INSPECT LEVEL 21

NOTE: ADD A COPY OF THIS W/O TO EACH P/N ABOVE

02/06/07

Job Completion



W 06/06/07